

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025056**Date Inspected:** 24-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

OBG –Bay 16

This QA Inspector observed the following work in progress,

Flux cored Arc Welding (FCAW)

Weld joint- 004, Located on stiffener to Side plate in Crash Barrier E2-SAS-1-001. Welder is identified as 201074.

ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2133 –ESAB.

Shielded Metal Arc Welding (SMAW)

Weld joint- 093, Located on stiffener in Crash Barrier E2-SB24-001. Welder is identified as 201861. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2112 –FCM-1.

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OBG –Bay 19

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Weld joint- 002/ 004, Located on Edge plate cover in Bike path BK 24A. Welder is identified as 259906. ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212 –TC-U4B-FCM-1.

OBG –Bay 14

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Weld joint- 028, Located on LD to stiffener in Segment 14W –SEG3020Y. Welder is identified as 067829. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113 –FCM-1.

Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as OBG Lift 14W components. The weld designations reviewed are as follows:

SEG 3020 K – Jt. nos -004,006,013,014,016,017,018,020,025,318,347,352,350,327,
SEG 3020K- Jt. nos -302,306,330,331,309,310,335,336

For further information's, see the pictures below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Baskar,Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer